

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007481**Date Inspected:** 08-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of the blast shop)

Segment 6AE

During a preliminary random visual inspection of the internal components of Segment 6AE, Caltrans Quality Assurance (QA) Inspector discovered the following fabrication issues by Visual Testing (VT) on welds previously inspected and accepted by ZPMC Quality Control (QC) Inspectors. See incident report on this date.

1.The connecting angle plates, for the T-rib to floor beam web bolted connection were found to be misaligned in a total of nine (36) locations throughout the segment. The misalignment was measured to be between 5mm to 15mm and occurs from panel point 37 thru 40.

2.The radius cut outs for the deck panel rib stiffeners were found to be misaligned in way of corner segment assembly at panel points 37 thru 40.

Bay 13

Lift 8 Corner Assemblies

During in process visual inspection of the fabrication of corner assemblies for OBG Lift 8, Caltrans Quality Assurance (QA) Inspector discovered the following welding related fabrication issues. These areas have not been inspected or accepted by ZPMC Quality Control (QC) Inspectors.

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1.The corner assembly web plates to open rib stiffener connections in corner assembly 48C were found to have excessive gaps of up to 10.5mm.

2.The single pass fillet weld sizes for the corner assembly 53D web plate to bottom plate connection were measured to be up to 18mm for joints welded in the 3G position. The weld designations are as follows CSD3-PP71-023, 024, 027, 028, 031 and 032.

Blast Shop

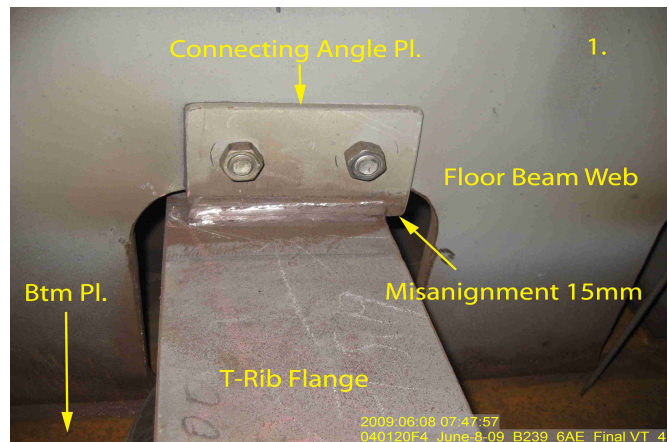
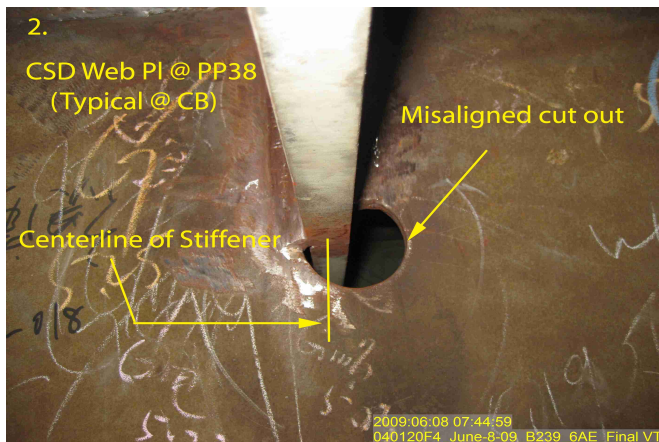
Segment 5CW

This QA Inspector performed a preliminary random visual inspection of the Upper Internal structure of this segment after the grit blast. Areas that were marked to be ground were repaired and areas that were marked to be welded were taped and noted to be repaired at the trial assembly yard. The ZPMC (QA) representatives were not present at the time of inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Patterson,Rodney

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer